

Date: Thursday, 07/12/2006 6:55:36 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 29769		Part Number	: D1048		
Estimate Number	: 10584		Drawing Number	: D1048 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 07/12/2006	S.O. No.	: N/A		Drawing Revision	: A
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 15/01/2007		
Previous Run	: 29769		Qty:	50	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: B 02.02.22 Re-format NG Est Rev:C Now on Waterjet 06-12-06 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s) 304/316 .063 Sheet Batch: M101873 ml 07/01/05
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D1048 Dwg Rev: A Prog Rev: A ml 01 01 09
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 01 01 09
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

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Drawing Name: CLAMP

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF 07-01-26 49

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/01/29 49

8.0 POWDER COATING POWDER COATING



M100700



49x

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m.b/a.m

07/01/31

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 11/02/06 (49)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 11/02/06 (49)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 07/02/07 (49)

Job Completion



U 07/02/07

Date: Tuesday, 12/5/2006 8:14:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 29769		Part Number	: D1048		
Estimate Number	: 10584		Drawing Number	: D1048 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/5/2006		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 1/15/2007		
Previous Run	: 27091		Qty:	50	Um:	Each
Written By	:		KA 06 12 05			
Checked & Approved By	:					
Comment	: Est: B 02.02.22		Re-format NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  Comment: PURCHASING Issue P/O: _____ Stamp and deburr per dwg D1048 Material: Stainless steel T304#2B Supply release not for Material.
2.0	D1048F	Clamp  Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s) CLAMP
3.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK  Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg. 2-Form as per dwg D2010 using DT8053

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (X) Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/07	2.0	DXF Program was wrong holes were 1.38 center to center, but were supposed to be 1.705	<u>J</u> QSL042	fix <u>Program</u> , Destroy Peices and re-cut	<u>E</u> 07.01.07 <u>M</u> 07/01/07	<u>J</u> 07/01/07	<u>J</u> QSL042	<u>J</u> 07/01/07
07/01/07	6.0	Bracket off center	<u>J</u> QSL042	SCRAP + Destroy No replace.	<u>FF</u> 07/01/07	<u>J</u> 07/01/07	<u>J</u> QSL042	<u>J</u> 07/01/07

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
9/10/02 RCL

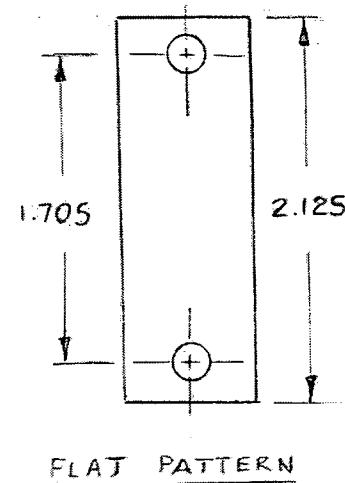
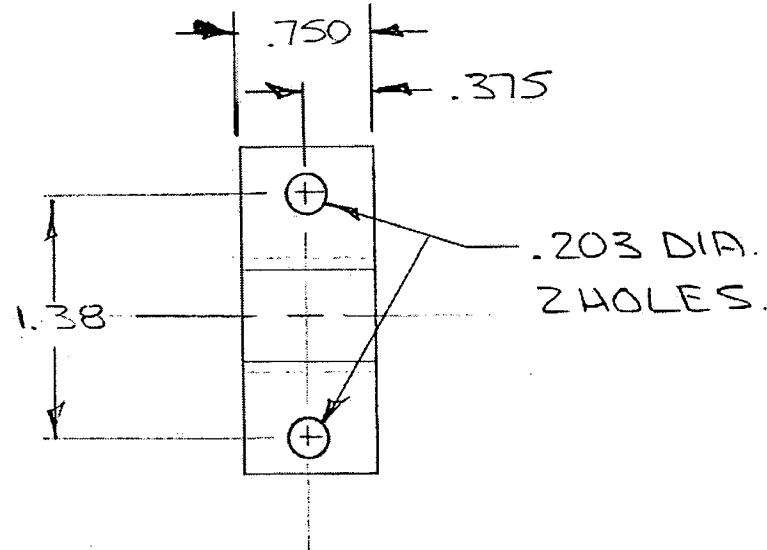
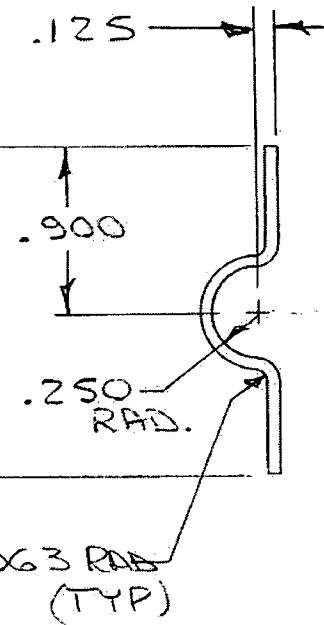
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



NO. 211205
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOP COPY
RETURN TO
ENGINEERING

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL

LIMITS

1. DIMENSIONS ARE IN INCHES
2. SURFACE ROUGHNESS .004
3. REMOVE SHARP EDGES .015 MAX
4. THREADS PER INCH - S - 1742
5. HOLES PER INCH 10307

1. TOLERANCES — XXX ± .000
XXX ± .010
2. ANGLES — ± .005
3. PARALLELISM — ± .0025
4. ECCENTRICITY — .005 MAX
5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005

REPORT ALL DISCREPANCIES — DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523

BASIC CODE

0-HANDLE

0-COUNTERSINK

0-COUNTERSINK

0-HANDLE

0-COUNTERSINK

PART NO.

CONTRACT NO.

DRAWN

DESIGN

STRESS

CHECKED

CLIENT

ITEM

DATE

BRADLEY

1/91

CLAMP

MATERIAL

DART AERO ACCESSORIES INC.

VANCOUVER

CANADA

CONFIDENTIAL
DRAFT

CLAMP

D 1048

A

A 01/12/05 AND FLAT PATTERN	REVISION RF APPROVED	DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES B1-M20410AD B2-M20416AD	PART NO. CONTRACT NO. DRAWN DESIGN STRESS C HECKED CLIENT	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
			GENERAL	LIMITS						
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .004 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 1742 5. HOLES PER INCH 10307	1. TOLERANCES — XXX ± .000 XXX ± .010 2. ANGLES — ± .005 3. PARALLELISM — ± .0025 4. ECCENTRICITY — .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005						

DART AEROSPACE LTD

Work Order: 29769

Description: Clamp

Part Number: D1048

Inspection Dwg: D1048 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:

Mr. M

Audited by:

11

Prototype Approval:

Date: _____

07 01 09

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	